

SPLIT-2

Work Order ID 68799 - 2

Thursday, April 21, 2011 7:28:44 AM



Item ID: D2893-1

Accept



Setup Start



Revision ID:

Item Name: 2.75 Support

Stop



Start Date: 4/21/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

QC:

Date: 4/21/11

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2893

Rev B

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA081 Tumble & Deburr

11.5.12
OK 11/05/17

9 0

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11.5.12
OK 11/05/17

9 0

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

B.A 11/05/17

9 0

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Page 2

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Stop



Sequence ID/
Work Center ID

Operation
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Set Up/
Run Hours

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Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M 11/6 964.

Memo

0.00

Mask Inside Bore for Priming START TIME:
7:00° OVEN TEMPERATURE: 8:10 FINISH
TIME: 8:40

9

BR 11-5-18

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

9 8 11-5-18

150



SprayPaint

Spray Painting

SprayPaint

0.00

Memo

0.00

Prime inside surface as per Dwg D2893 and QSI 005 4.3

RT 11-05-19 (x9)

Work Order ID 68799

Thursday, April 21, 2011 7:28:44 AM



Page 3

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Customer:

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

8 x 105/20

(+9)

x tube
any

BT 11-05-20 (+9)

11/5/24

MF
11-05-20

Picklist Print

Thursday, April 21, 2011 7:29:14 AM

Page 1

Work Order ID: 68799



Parent Item: D2893-1



Parent Item Name: 2.75 Support

Start Date: 4/21/2011

Required Date: 4/27/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: C 02.11.26 Reformat: Added P/O KJ
IPP D 06.04.19 removed alodine EC
IPP Rev:E Added priming as per Rev B 07-04-30 JLM
IPP F 08.03.19 Re-format EC verified by: DD
IPP Rev:G 08-05-15 add QC14 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	0.0000	0.5	10			



D2893-1 TURNING DETAIL

B 68476



5
and 11/05/17

DART AEROSPACE LTD		Work Order:	07799
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.996	2.995	3.000	2.995	2.993
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.126	.127	.127	.127	.127
AD	0.040	0.060		.050	.057	.049	.050	.050
AE	0.188	0.193		.190	.190	.190	.190	.190
AF	0.125	0.160		.140	.140	.140	.141	.140
AG	0.140	0.160		.150	.152	.151	.152	.152
AH	1.360	1.400		1.371	1.375	1.375	1.372	1.374
AI	0.040	0.060		.054	.052	.053	.052	.053
AJ	1.190	1.230		1.215	1.218	1.215	1.214	1.216
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.520	2.520	2.520	2.520	2.520
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.263	.263	.263	.263	.263
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>mk</i>	Date:	11/05/17
Audited by:	<i>B.A</i>	Date:	11/05/17
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	01799
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

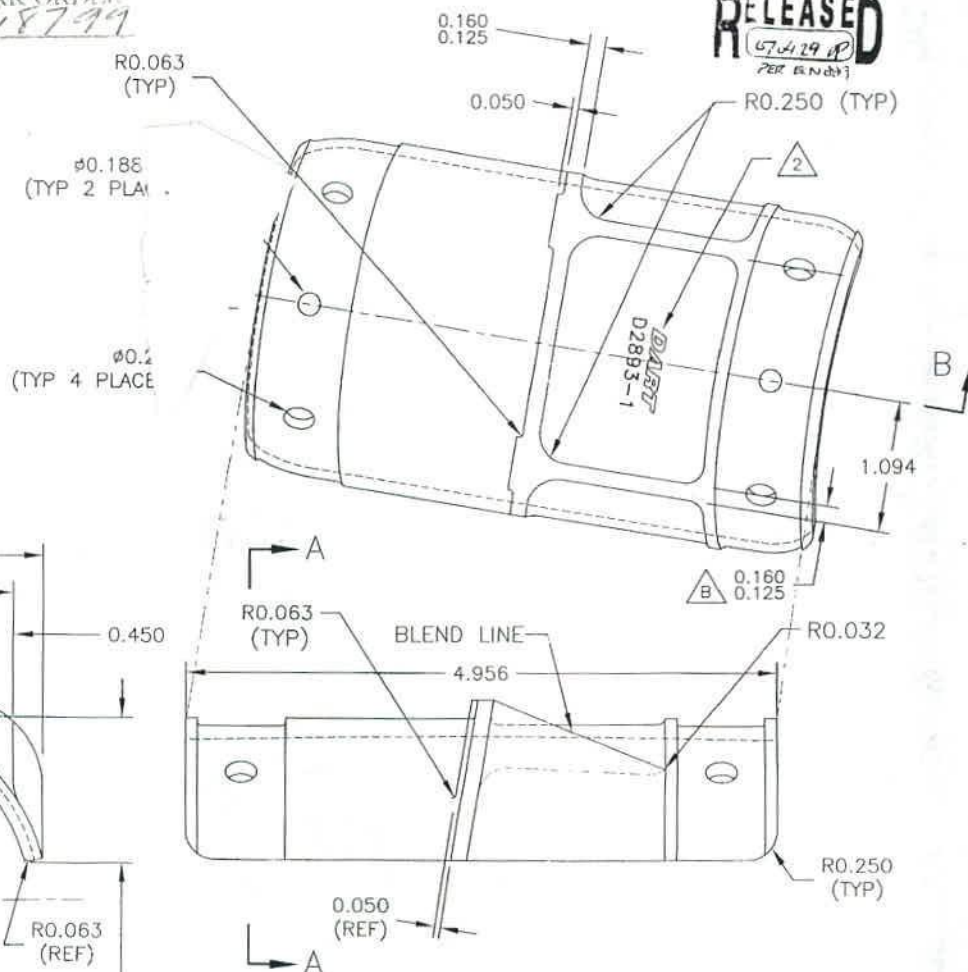
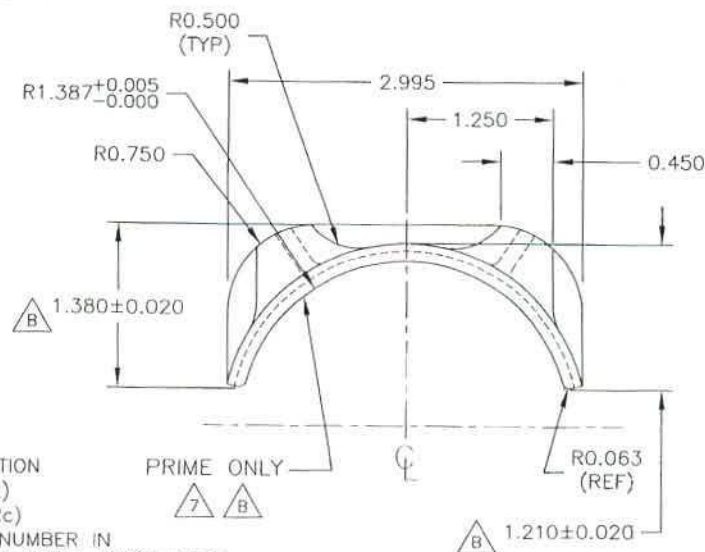
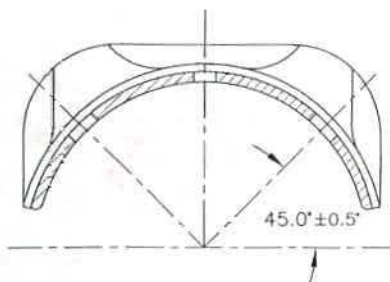
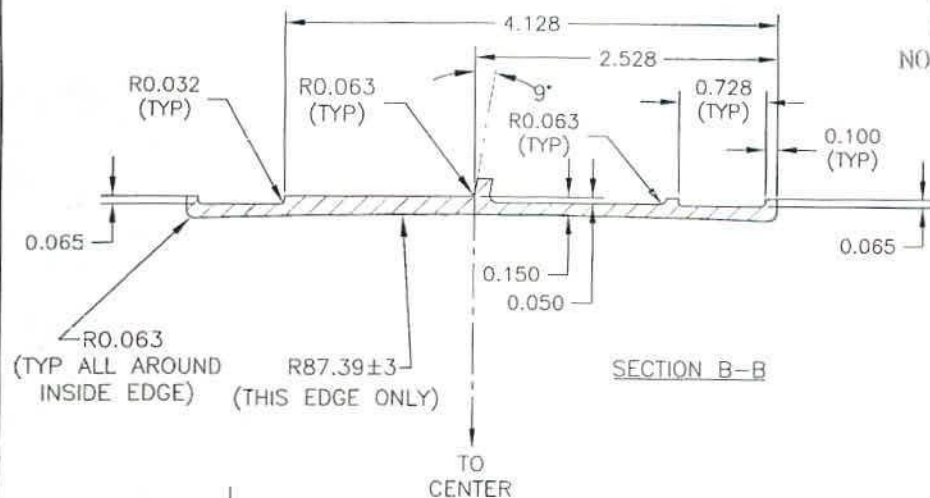
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	5
HAAS Section								
AA	2.985	3.005		2.996	2.997	2.997	2.997	
AB	0.440	0.460		.440	.440	.440	.440	
AC	0.125	0.160		.128	.128	.129	.129	
AD	0.040	0.060		.050	.050	.048	.048	
AE	0.188	0.193		.190	.190	.190	.190	
AF	0.125	0.160		.140	.140	.140	.140	
AG	0.140	0.160		.151	.151	.149	.152	
AH	1.360	1.400		1.374	1.372	1.375	1.374	
AI	0.040	0.060		.052	.053	.053	.052	
AJ	1.190	1.230		1.216	1.215	1.217	1.214	
AK	0.010	0.020		.015	.015	.015	.015	
AL	0.053	0.073		.063	.063	.063	.063	
AM	0.240	0.260		.250	.250	.250	.250	
AN	2.518	2.538		2.523	2.520	2.525	2.520	
AO	84.39	90.39		87.39	87.39	87.39	87.39	
AP	0.261	0.266		.263	.263	.263	.263	
AQ	0.053	0.073		.063	.063	.063	.063	
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>SMX</i>	Date:	11/05/17
Audited by:	<i>A.A</i>	Date:	11/05/17
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>[Signature]</i>

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 48799



D2893-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN
THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

B	07.03.16	UPDATE DIMS AS MFG., PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2893
DATE	TITLE	REV. B SHEET 1 OF 1 SCALE
07.03.16	#2.750 SUPPORT	1:1